

Date: Thursday, 9/20/2007 3:29:14 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 34751	
Estimate Number : 10534	
P.O. Number : <i>N/A</i>	Part Number : D2574
This Issue : 9/20/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2574 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 34370	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/1/2007 Qty: 12 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev. As Per RevE 06-01-27 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)  
7075-T7351 8.25X5.0X2.5  
Make from D6101-005 billet for D2574  
Ensure that grain is along 5.00" length  
Batch No: *B31388*

*J.L. 07/10/02 12*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
Program Batch No. *34751* Double check by: *SC*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets  
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
4-Deburr and remove all machining marks  
5-Tumble to remove sharp edges.

*J.L. 07/10/02 12*

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE  
Machine keyway as per dwg D2573 & D2574

*J.L. 07/10/02 12*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.L. 07/10/02 12*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 9/20/2007 3:29:14 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 34751

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*mk 07/10/15*

(12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*M-L*

*07/10/15*

(12x)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*M105088*

*ll*

*09-10-16*

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*ll 07/10/16*

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*ll 07/10/16*

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*ll 07/10/17*

(12)

Job Completion



*ll 07-10-17*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>34751</b>
<b>Description: Saddle, Aft Inboard</b>	<b>Part Number:</b>	<b>D2574</b>
<b>Inspection Dwg: D2574 Rev. E</b>		<b>Page 1 of 1</b>

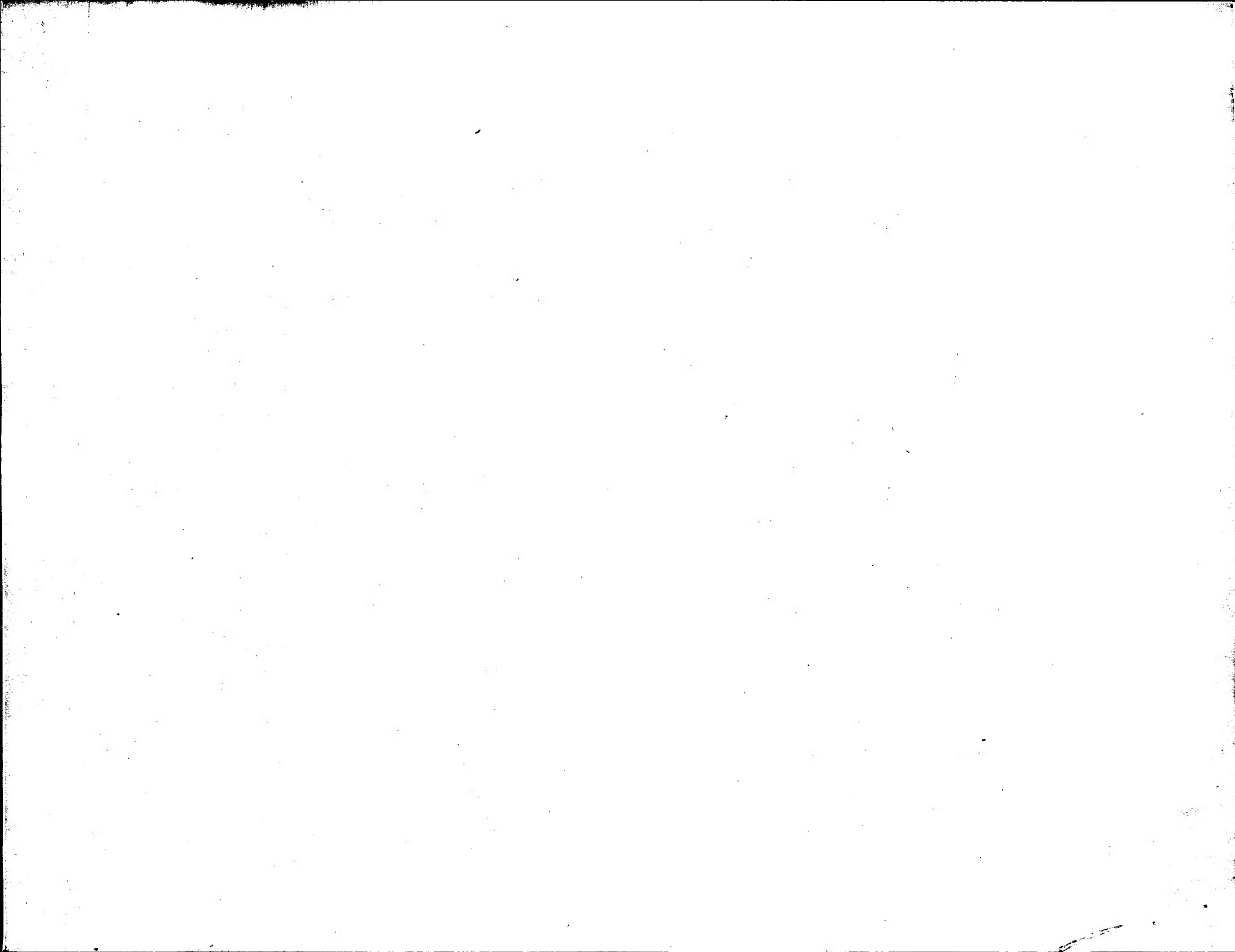
Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	<del>DT8682</del>	0.441	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.498	3.497		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	7.999	8.007	8.004		
F	0.490	0.510		0.501	0.503	0.502	0.500		
G	0.257	0.262	<del>DT8683</del>	0.259	0.258	0.258	0.259		
H	0.375	0.380	<del>DT8684</del>	0.377	0.377	0.376	0.377		
I	0.490	0.510		0.502	0.501	0.502	0.503		
J	1.174	1.184		1.179	1.179	1.178	1.181		
K	0.558	0.578		0.570	0.570	0.570	0.570		
L	1.174	1.184		1.179	1.179	1.178	1.181		
M	1.365	1.375		1.369	1.369	1.368	1.368		
N	2.495	2.505		2.499	2.499	2.499	2.500		
O	4.119	4.129		4.121	4.121	4.122	4.125		
P	0.115	0.135		0.124	0.124	0.124	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.248	0.249	0.250		
S	0.115	0.135		0.129	0.129	0.128	0.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.228	3.230	3.230	3.230		
V	0.230	0.250		0.238	0.236	0.237	0.237		
W	0.115	0.135		0.129	0.127	0.127	0.127		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.764	0.764		
Z	0.352	0.372		0.366	0.366	0.370	0.370		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.626	0.624	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.247	0.247	0.247		
AE	1.500	1.520		1.509	1.510	1.510	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.136		
AG	0.240	0.280		0.265	0.275	0.270	0.270		
AH	0.240	0.260		0.249	0.247	0.248	0.246		
AI	2.000	2.020		2.000	2.001	2.001	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: <b>RF / J.L.</b>
Date: <b>02.10.11</b>

Audited by: <b>[Signature]</b>
Date: <b>07/10/15</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<b>[Signature]</b>



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	34751
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b>	D2574
<b>Inspection Dwg:</b> D2574 Rev. E		Page 1 of 1

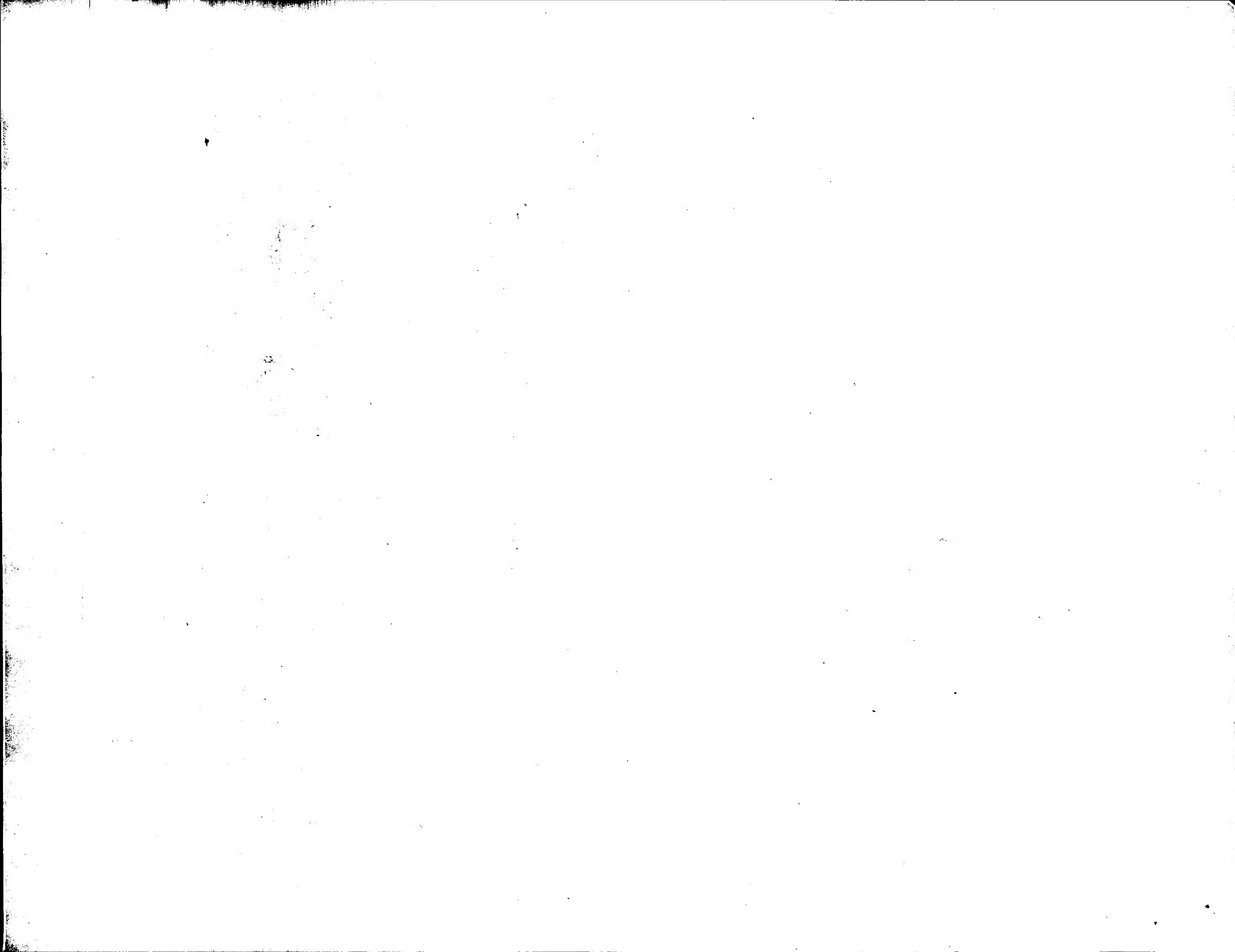
Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5*	62	73	84	By	Date
A	0.438	0.443	<del>DT8682</del>	.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.002	8.005		
F	0.490	0.510		.508	.508	.508	.508		
G	0.257	0.262	<del>DT8683</del>	.259	.259	.259	.259		
H	0.375	0.380	<del>DT8684</del>	.377	.377	.377	.377		
I	0.490	0.510		.506	.506	.505	.505		
J	1.174	1.184		1.183	1.183	1.183	1.181		
K	0.558	0.578		.576	.572	.572	.572		
L	1.174	1.184		1.182	1.183	1.183	1.181		
M	1.365	1.375		1.371	1.371	1.372	1.371		
N	2.495	2.505		2.500	2.501	2.500	2.499		
O	4.119	4.129		4.121	4.124	4.124	4.123		
P	0.115	0.135		.124	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.253	.251	.251	.251		
S	0.115	0.135		.125	.125	.125	.125		
T	0.178	0.198		.183	.184	.184	.188		
U	3.210	3.250		3.230	3.234	3.234	3.231		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.120	.122	.122	.122		
X	0.307	0.312		.311	.311	.311	.311		
Y	0.760	0.765		.764	.764	.764	.764		
Z	0.352	0.372		.369	.369	.369	.369		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.511	1.511	1.510	1.511		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.010	2.016	2.010	2.010		
AJ	0.023	0.043		.040	.040	.040	.040		
Accept/Reject									

Measured by:	S.F.
Date:	07/20/01

Audited by:	JME
Date:	07/10/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	





<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	34751
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b>	D2574
<b>Inspection Dwg:</b> D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9-A	2-10	2-11	4-12	By	Date
A	0.438	0.443	<del>DT8682</del>	.440	.446	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.005	8.005	8.005	8.005		
F	0.490	0.510		.505	.505	.505	.505		
G	0.257	0.262	<del>DT8683</del>	.258	.258	.258	.258		
H	0.375	0.380	<del>DT8684</del>	.377	.376	.376	.376		
I	0.490	0.510		.503	.503	.503	.503		
J	1.174	1.184		1.180	1.179	1.179	1.179		
K	0.558	0.578		.571	.571	.571	.571		
L	1.174	1.184		1.180	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.127	.125	.125	.125		
Q	0.115	0.135		.132	.132	.132	.132		
R	0.240	0.260		.251	.250	.250	.250		
S	0.115	0.135		.132	.132	.132	.132		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.228	3.232	3.232	3.232		
V	0.230	0.250		.237	.237	.237	.237		
W	0.115	0.135		.130	.130	.130	.130		
X	0.307	0.312		.311	.311	.311	.311		
Y	0.760	0.765		.764	.764	.764	.764		
Z	0.352	0.372		.365	.365	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.628	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.252	.252	.252		
AE	1.500	1.520		1.509	1.509	1.509	1.509		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.256	.270	.270	.270		
AH	0.240	0.260		.251	.251	.251	.251		
AI	2.000	2.020		2.010	2.010	2.010	2.010		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	JF
Date:	02/10/07

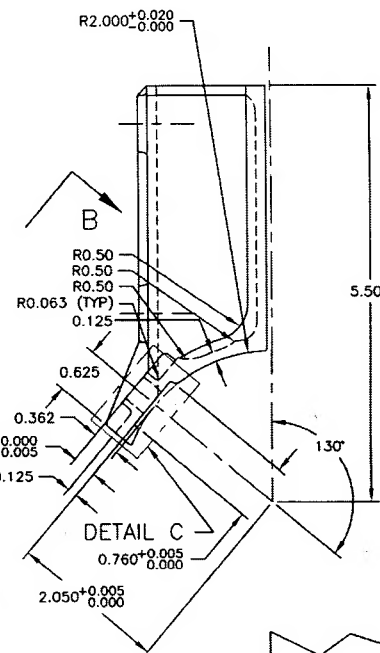
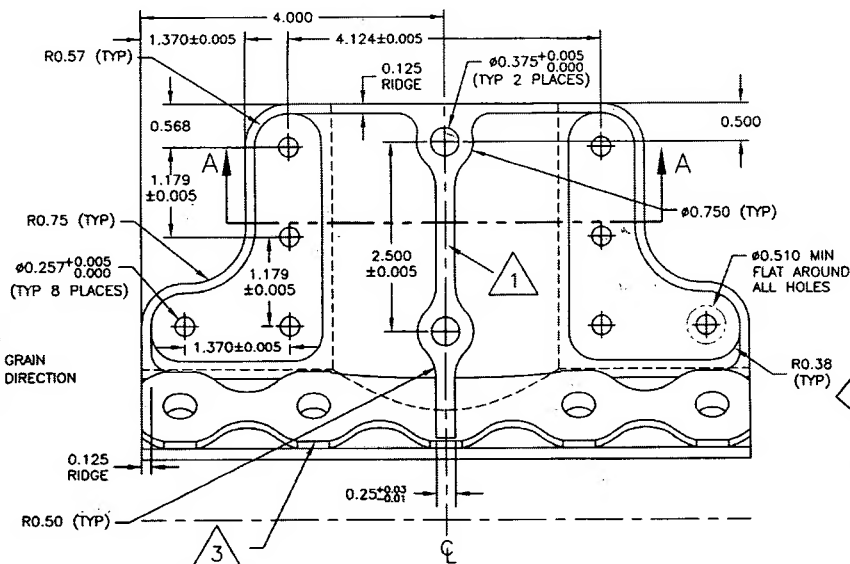
Audited by:	JML
Date:	02/10/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



RELEASED

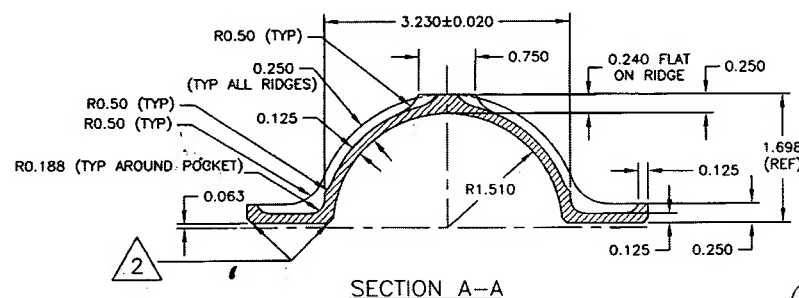
05.12.06



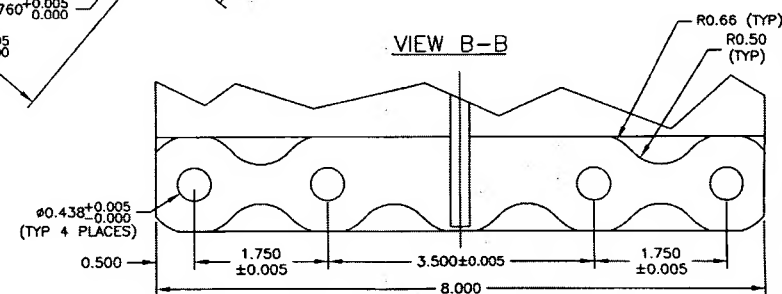
# NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

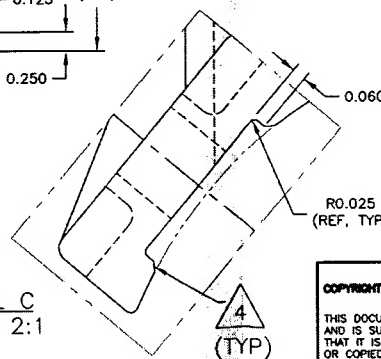
- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)



SECTION A-A



VIEW B-B



DETAIL C  
SCALE 2:1

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	05.07.13	TITLE
		INNER AFT SADDLE

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DART AEROSPACE LTD.

**DART AEROSPACE LTD.**  
HAMPSHIRE, OXFORD, CANADA  
REV. E  
SHEET 1 OF 1  
SCALE 2:3

NO. 34751  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY  
34751